

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: AK Date: 12/11/02QA Closed: ck Date: 12/11/05

Work Order: <u>90561</u> Part No. <u>03167-1</u> NCR No. <u>12-2001</u>				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input checked="" type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input checked="" type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>						Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input checked="" type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
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FAULT CATEGORY																											
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube			General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio			<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions			<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input checked="" type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input checked="" type="checkbox"/> Other																		

Work Order ID 90561

90561

Page 2

September-19-12 2:36:09 PM

Item ID: D3167-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Bearpaw
 Start Date: 9/18/12 Start Qty: 4.00 *4* Cust Item ID:
 Required Date: 10/05/12 Req'd Qty: 4.00 *4* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC8- Inspect parts - second check	0.00							
150									
QC	Memo	0.00							
Quality Control									
151	Identify as per dwg & Stock Location: _____	0.00							
151									
Packaging	Memo	0.00							
Packaging									
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									

12-10-30

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Picklist Print

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Page 1

Work Order ID: 90561

Parent Item: D3167-1

Parent Item Name: Bearpaw

Start Date: 9/18/12

Required Date: 10/05/12

Start Qty: 4.00

Required Qty: 4.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10		Purchased	No			120	sf	249.7100	3.6	14.4 14.5			
UHMW 1" Black													Jm 12-10-10
				Location	Loc Qty		Loc Code						
				MAT018	226.6								
				118814	0								
				120972	1								
				121346	27.1								
				121954	12.8								
				122286	14.3								
				122575	23.8								
				122722	147.6								
				MAT019	1.5								
				118814	1.5								
				ST052	21.60999474								
				121277	12.8								
				121278	8.80999474								

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DART AEROSPACE LTD		Work Order:	90561
Description: Bearpaw		Part Number:	D3167-1
Inspection Dwg: D3167 Rev: A1		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.06 x 45°	+0.030/-0.010	.060	✓		VERN	P40-01
B	5.80	+/-0.030	5.793	✓		"	"
C	0.25 x 45°	+/-0.030	.250	✓		M TAPE	P40-11
D	R0.25	+/-0.030	.250	✓		R-G.	
E	0.200	+/-0.030	.193	✓		MIC	P40-09
F	0.250	+/-0.010	.246	✓		VERN	P40-01
G	0.625	+/-0.030	.623	✓		"	"
H	0.375	+/-0.010	.375	✓		"	"
I	0.950	+0.030/-0.010	.950	✓		"	"
J	3.21	+/-0.030	3.21	✓		"	"
K	19.00	+/-0.030	19.00	✓		M TAPE	P40-11
L	Ø0.260	+0.005/-0.000	.260	✓		VERN	P40-01
M	Ø0.93	+/-0.030	.930	✓		"	"
N	0.30	+0.030/-0.000	.301	✓		MIC	P40-09
O	0.375	+/-0.030	.375	✓		VERN	P40-01
P	7.23	+/-0.030	7.23	✓		M TAPE	P40-11
Q	4.54	+/-0.010	4.54	✓		VERN	P40-01
R	2.00	+/-0.030	2.016 ^{1.997}	✓		"	"
S	12.000	+/-0.010	12.000	✓		M TAPE	P40-11
T	6.000	+/-0.010	6.000	✓		VERN	P40-01
U	23.75	+/-0.030	23.75	✓		M TAPE	P40-01

Measured by:	PD
Date:	12/10/25

Audited by:	DAS 08
Date:	12/10/26

Prototype Approval:	N/A
Date:	N/A

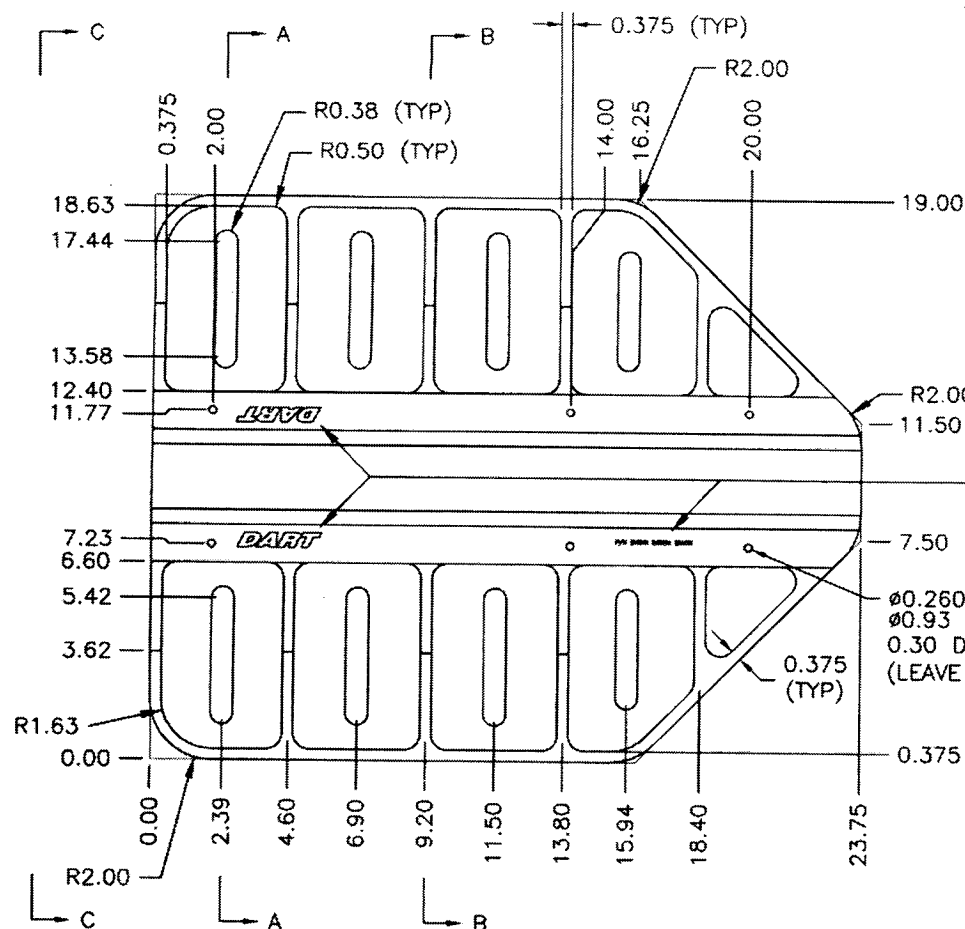
Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O D130-700-011	KJ/RF	✱



DESIGN		DRAWN BY		DART AEROSPACE LTD	
CHECKER		APPROVED		HAWKSBURY, ONTARIO, CANADA	
DATE		DRAWING NO.		REV. A	
02.10.08		D3167		SHEET 1 OF 2	
		TITLE		SCALE	
		BEARPAW		1:6	
A		02.10.08		NEW ISSUE	
A1		02.12.17		5.80 WAS 5.50	

STANDARD COPY
REVISION
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO ENDORSEMENT
WITH NOTICE
WORK CENTER
NO 90561 ML5
12-09-20

ENGRAVE LOGO TO MAX
DEPTH OF 0.012. ENGRAVE
PART AND BATCH NUMBERS
TO MAX DEPTH OF 0.010.
(TYPICAL LOCATION AS
ILLUSTRATED)



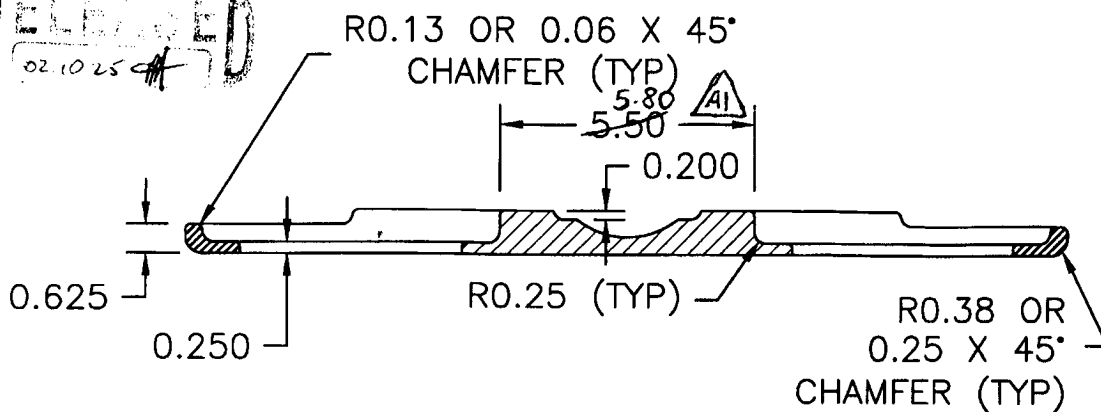
D3167-1

MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
1.00 THICK (MACHINE TO 0.950)
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

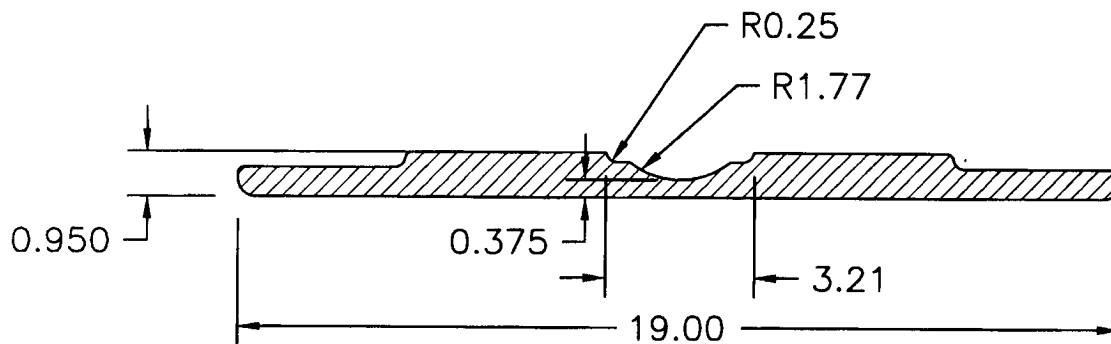


DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3167	REV. A SHEET 2 OF 2
DATE 02.10.08		TITLE BEARPAW	SCALE 1:4

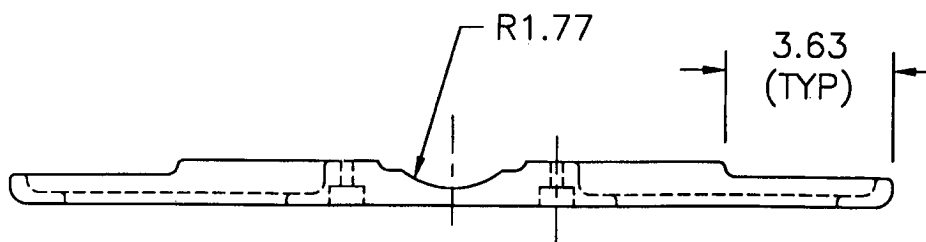
RELEASED
02.10.25 *[Signature]*



SECTION A-A



SECTION B-B



SECTION C-C

90561

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